Quality Control

DQA: Date:	
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NCR: Y	es / No				WORK ORDER NON-	CONF	UKI	VIANCE / UP	DAIE			
										QA Closed:	Date	:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap] "		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
raicie	····				Use-as-is	┪┃┰		noforming	Finishing		re/Packaging	Other
NCR N	lo				Work Order Update	╛╽╵	11611	Large Fab	Composite	nec/sto	Supplier	
Root				Descri	iption of work order update	Initi	ial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data						.1	۴					
Equip/Tooling												
Operator [}		'		1						
Material [·
Setup						1						
Other												
Process												
Supplier			•									
Training]				
Unapproved												
			•		, , , , , , , , , , , , , , , , , , ,	FAULT C	ATE	GORY				
Landin	ng Gear		<u> </u>		General			· · · · · · ·	<u> </u>			
	Bending				Bend	Gr	ain			Ovalized		Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	На	rdwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	pect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Ins	truct	ions Incomplete/U	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	M	ainte	enance		Part Moved		
	Heat Trea	at			Countersink	Mi	slabe	eled		Positioned V	Vrong	_
Ī	Inspectio	n Strip in	Tube		Cut Too Short	Mi	srea	d		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes	Of	fset					
	Torque W	/aves in E	extrusio	n [Drawing		t of	Calibration				
	Turning S	equence			Finish	Ou	t of S	Sequence				
	Wave/Tw	ist in Tub	oe .		Folio	Ou	tside	Dimensions				

Work Orde October-03-13		7799		k	107	79	99*							Page 2
Item ID: Revision ID:	D3137-043		A	ccept		*1	1900	040	100)*	Setup		ıv.	S1*
Item Name:	Bracket Assen	nbly										Stop	*N:	S2*
Start Date: Required Date: Reference:	10/03/13 10/17/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*				Cust Item II Customer:	D :						
Approvals:	Process Pla	n:	Date:	Toolin	σ•		Da	te:	-		Run	Start	*NI	R1*
approvals.				SPC (Y				te:				Stop		R2*
Sequence ID/ Work Center II	0	Operation Description		Set Rur	Up/ Hours		Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
130		QC8- Inspect parts - seco	ond check	0.00						e				
130 QC Quality Control		Memo		0.00	10AS		13/10/15	5		6	_ Ø			
140				0.00										0.
140 Small Fab		Small Fab Memo Assemble D	3137-043 as per Dwg D313	0.00						67	<u>-</u>	_ -		J3]
						-					`			
150		QC5- Inspect part compl	eteness to step on W/O	0.00	DAS 27					Í				
150 QC		Memo		0.00	13 [0	Ø				6				

Quality Control

NCR:	Yes	1	No
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DQA: ____ Date: __

NCR: Y	es / No				WORK ORDER NON-C	ONFOR	IMANCE / UP	DATE	QA Closed:	Date	::	
Work Orde	r.				DISPOSITION			AGAINST DI	PARTMENT	/PROCESS		
Part N	· · · · · · · · · · · · · · · · · · ·				Rework Scrap		Skid-tube Machining	Crosstube Small Fab	}	Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	o			 	Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite				
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector	
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Landin	g Gear	-			General					_	_	
	Bending				Bend	Grain			Ovalized		Pressure/Forced	
Γ	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure	
Ī	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld	
Ī	Crushed/	Crimped			Burrs	Instru	ctions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
Ī	Cuffs				Contamination	Maint	tenance		Part Moved			
Ī	Heat Trea	at			Countersink	Mislat	eled		Positioned V	Vrong		
Ī	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other	
	Ripples in	-			Drill Holes	Offset		_	_			
Ī	Torque V	Vaves in E	xtrusio	n	Drawing	Out of	Calibration					
	Turning S				Finish	Out of	Sequence					
	Wave/Tw	vist in Tul	ре		Folio	Outsid	le Dimensions					

Work Order ID 107799 *107799* Page 3 October-03-13 9:04:12 AM D3137-043 Accept *N900040100* Item ID: Setup Start **Revision ID:** Stop Item Name: **Bracket Assembly Start Date:** 10/03/13 Start Qty: 6.00 **Cust Item ID:** Required Date: 10/17/13 Req'd Qty: 6.00 **Customer:** Reference: Run **Tooling: Approvals:** Process Plan: Date: Date: Stop SPC (Y/N): QC: Date: Date: Reject Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Operation Accept Insp. Oty Qty Work Center ID Number Stamp Description **Run Hours** Code Identify as per dwg & Stock Location: ST235A 160 6x 28 13-10-16 *160* Packaging 0.00 Memo Packaging

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

170

170

Quality Control

MB-10-17

		DQA:	Date:	
NCD: Voc / No	WORK OPDER NON-CONFORMANCE / LIPRATE	-		

NCR:	⁄es	/ No				WORK ORDER NON-O	100	NFORI	MANCE / UP	DATE	QA Closed:	 Date	
			· · · -			·			·	-	QA Closed.	Date	·
Work Orde	∍r:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	- No					Scrap Ma Use-as-is Thermo		~ ~		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other		
Root		5.4	C.	٥.	1	ption of work order update	1	Initial		tion	Sign &	Vanifia Aian	OC Imamentary
Cause		Date	Step	Qty	•	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		·										e e e e e	. •
•						F	AUL	T CATE	GORY				
Landi	_	1				General		,		-	7	_	- .
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	st ssing //rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
		Torque W	/aves in l	Extrusio	n 🗍	Drawing		Out of Calibration					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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Picklist Print

October-03-13 9:04:15 AM

Work Order ID: 107799

107799

Parent Item:

D3137-043

D3137-043

Parent Item Name: Bracket Assembly

Start Date: 10/03/13

Required Date: 10/17/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A04.02.18New issueKJ/DS

IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24694-S101 *MS24694- Screw	-S101*	Purchased	No			100	Each	53.0000	**	6	13/10	/16 0	ß
				Location		Loc	Qty	Loc Code			/ /		
				ST304			53		_		_	•	
					122441		53			6	_		
D3137-3		Manufactured	No			140	Each	6.0000	1	6			
D3137-3									**	·		13/10	1160
Juide				Location		Loc (<u>Oty</u>	Loc Code				/ /	
				ST235A			6				_		
					105717		6			_6	_		
D3137-5		Manufactured	No			140	Each	49.0000	1	6		_	/
D3137-5									**			13/1	0/10
				Location		<u>Loc</u>	<u>Oty</u>	Loc Code					
		•		ST235A			49				_		
					102867		49		_	6			
M174B0.500X02.000		Purchased	No			140	f	0.0000	0.4643	3			
M174R0 5 17-4 SS Bar .500 x 2.00	SUUXU5	იიი							**	4- 1 V			

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	CON	IFORI	MANCE / UP	DATE	QA Closed:	Date:	
Marili Orda			· .	·	DISPOSITION				AGAINST D	DEPARTMENT		
Work Orde	r:				Dawark	٦	Child Autho Concertula C			7	Water Jet	Engineering
Part N	0				Rework Scrap	┨╏		Skid-tube Machining	Crosstube Small Fab	Pro	d. Eng. Coor.	Quality
raitiv	··	·			Use-as-is	┨ ┠		noforming	Finishing		re/Packaging	Other
NCR N	o. 🐫				Work Order Update	┪┃		Large Fab	Composite		Supplier	
												
Root					iption of work order update		nitial		ction	Sign &	_	
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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Other			1		,					,		
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Landin	g Gear		· · · ·		General							
ſ	Bending			Γ	Bend		Grain		Γ	Ovalized		Pressure/Forced
Ī	Centre I	Not Conce	ntric to (o/s	BOM/Route	П	Hardwa	re		Over/Under	tolerance	Temperature/Cure
Ī	Cracks				Broken/Damaged		Inspecti	ion Incomplete	Γ	Part Incorre	ct	Weld
Ī	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	eat			Countersink		Mislabe	led		Positioned V	Vrong	,
	Inspecti	on Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes		Offset					
[Torque	Waves in I	Extrusion	۱ [Drawing		Out of 0	Calibration				
	Turning Sequence				Finish	Out of Sequence						

Outside Dimensions

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	1077991
Description: Bracket	Part Number:	D3137-7
Inspection Dwg: D3137 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

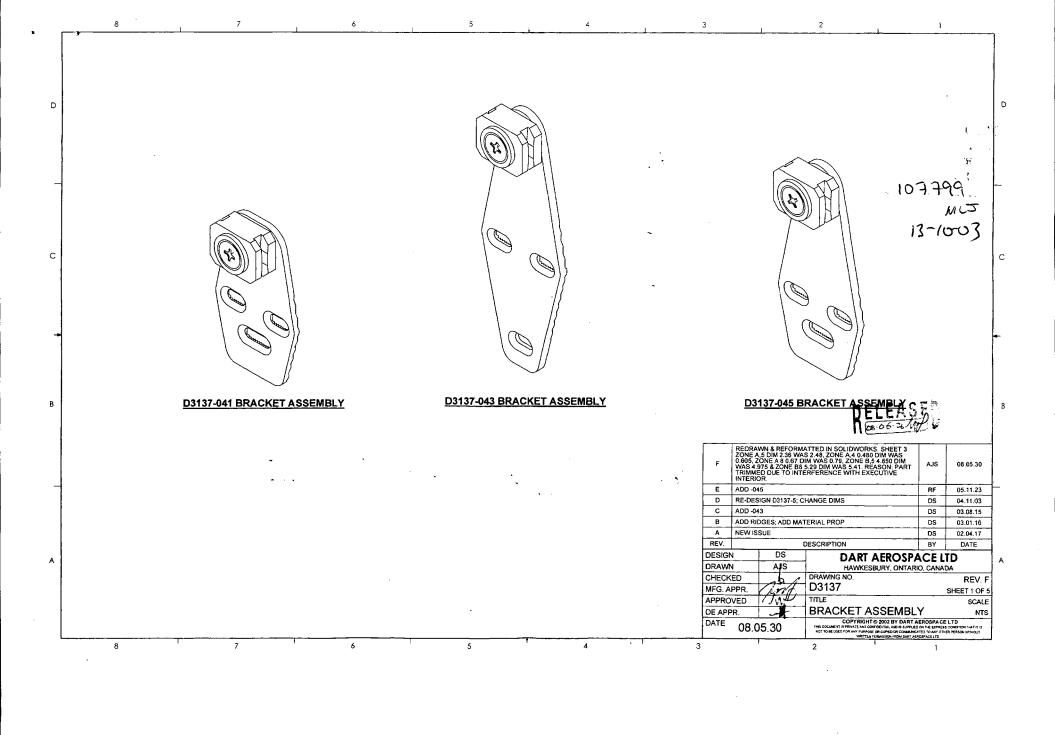
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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5.29	+/-0.030	5.287			· \	•
2.79	+/-0.030	2.790	1			
0.67	+/-0.030	.685				
1.90	+/-0.030	1.884	/			
0.262	+/-0.010	.261				
0.062	+/-0.010	063	/			
4.850	+/-0.010	4,849	V,			
0.162	+/-0.010	.156				
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2.360	+/-0.010	2,359	1			
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Measured by:	Audited by: 40	Preliminary Approval:	N/A
Date: 13/10/13	Date: \3//0/	Date:	N/A

Date	Change	Revised by	Approved
03.11.12	New Issue P/O D3137-043	KJ/RF	
04.06.15	Changed & added dimensions	KJ/JLM	
06.03.15	Dwg Rev updated	KJ/JLM	
08.12.02	Dwg Rev updated	KJ/DD LA	1.1
10.08.03	Dimension 5.29 was 0.529	KJ \$\langle	A
	03.11.12 04.06.15 06.03.15 08.12.02	03.11.12 New Issue P/O D3137-043 04.06.15 Changed & added dimensions 06.03.15 Dwg Rev updated 08.12.02 Dwg Rev updated	03.11.12 New Issue P/O D3137-043 KJ/RF 04.06.15 Changed & added dimensions KJ/JLM 06.03.15 Dwg Rev updated KJ/JLM 08.12.02 Dwg Rev updated KJ/DD

				DQA:	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

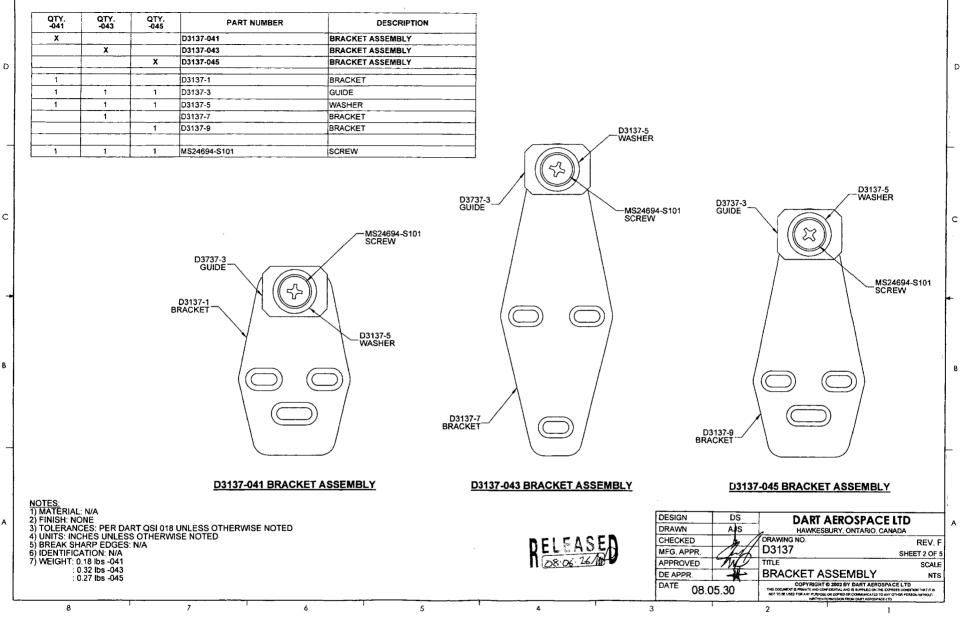
_											QA Closed	: Date	2:
Work Ord	er:	·				DISPOSITION				AGAINST DI	PARTMENT	PROCESS	
Part I NÇR I	No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			⊣	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ti	nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty	1	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			ļ				Ì						
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Training	$oxed{oxed}$] .			,				•	ľ		1
Unapproved			<u> </u>						İ		<u> </u>		
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Landi		7				General	_	1		_	7	r	٦
	<u> </u>	Bending				Bend	-	Grain		_	Ovalized	-	Pressure/Forced
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	\vdash	Cracks			<u> </u>	Broken/Damaged	\vdash	1	ion Incomplete	, <u> </u>	Part Incorre) —	Weld
	Crushed/Crimped					Burrs	-	1	tions Incomplete/	Unclear	Part Lost/M	_ <u>_</u>	Wrong Stock Pulled
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Torque Waves in Extrusion						Drawing	\vdash	4	Calibration	•	-		
Turning Sequence Wave/Twist in Tube						Finish	Out of Sequence						
1	1	wave/fw	vist in Tul	oe e		Folio	Outside Dimensions						



		DQA	: Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

									<u>.</u>		QA Closed:	Date	e:
Work Ord	er.		,			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng Description			Date	Verification	QC Inspector
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		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	'Crimped			Burrs		Instruct	tions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	enance	L	Part Moved		
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	-
		Inspectio	n Strip in	Tube		Cut Too Short	L	Misrea	t		Power Loss/	Surge	Other
		Ripples in			Drill Holes	L	Offset						
	Torque Waves in Extrusion Drawing							Out of	Calibration				
	Turning Sequence Finish							Out of	Sequence				
1		Wave/Tw	vist in Tul	be		Folio	Outside Dimensions						

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DQA:		Date:	
			

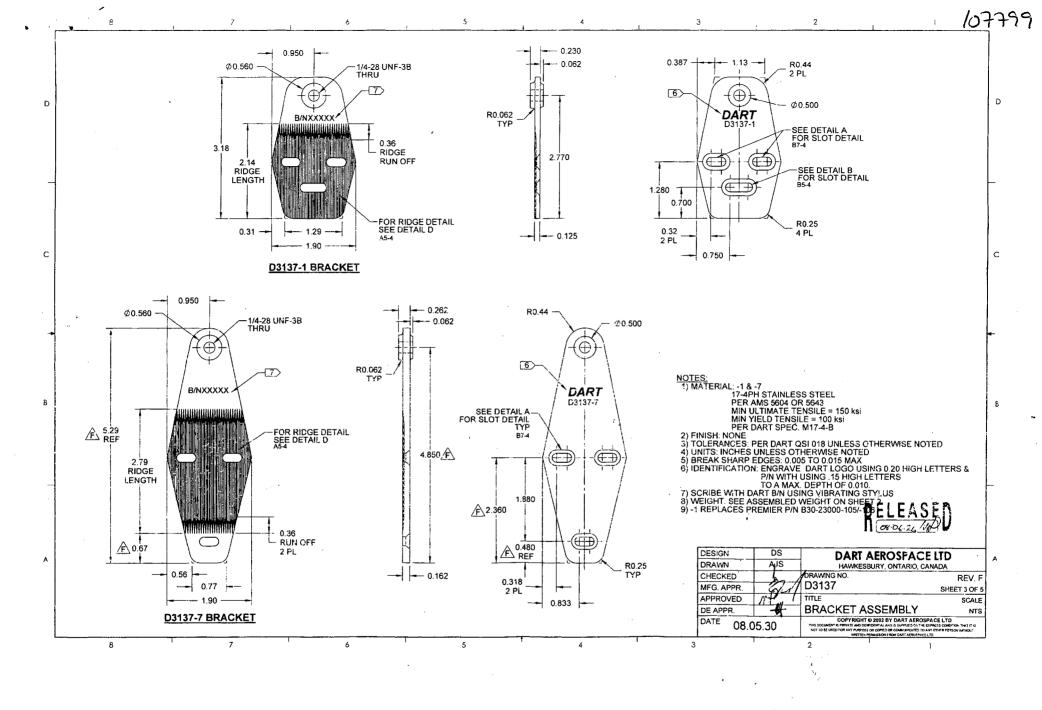
NCR:	Yes	/ No				WORK ORDER NOT	N-COI	NFORI	VIANCE / U	PDATE		QA Closed:	Date	e:	
Work Ord	eř.					DISPOSITION				AGAINS	T DE	EPARTMENT/PROCESS			
Part I	No.		-			Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fal Finishin Composite	g	Pro Rec/Sto	Engineering Quality Other		
Root					1	ption of work order update		Initial	i .	Action		Sign &		<i>i</i>	
Cause		Date	Step	Qty	ı	or Non-conformance	Cr	nief Eng	De	scription		Date	Verification	QC Inspector	
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ļ		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	are	* *		Over/Under	tolerance	Temperature/Cure	
		Cracks				Broken/Damaged		Inspect	ion Incomplete	:	Г	Part Incorre	ct	Weld	
		Crushed/	Crimped			Burrs		Instruc	tions Incomplet	e/Unclear		Part Lost/Mi	issing	Wrong Stock Pulled	
	Cuffs					Contamination		Mainte	enance		\vdash	Part Moved			
	П	Heat Trea	∍t			Countersink		Mislabe	eled			Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d			Power Loss/	Surge	Other	
	-	Ripples ir				Drill Holes		Offset			L	-	_		
		Torque W		xtrusio	n	Drawing		Out of	Calibration						
Turning Sequence						Finish	Out of Sequence								

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

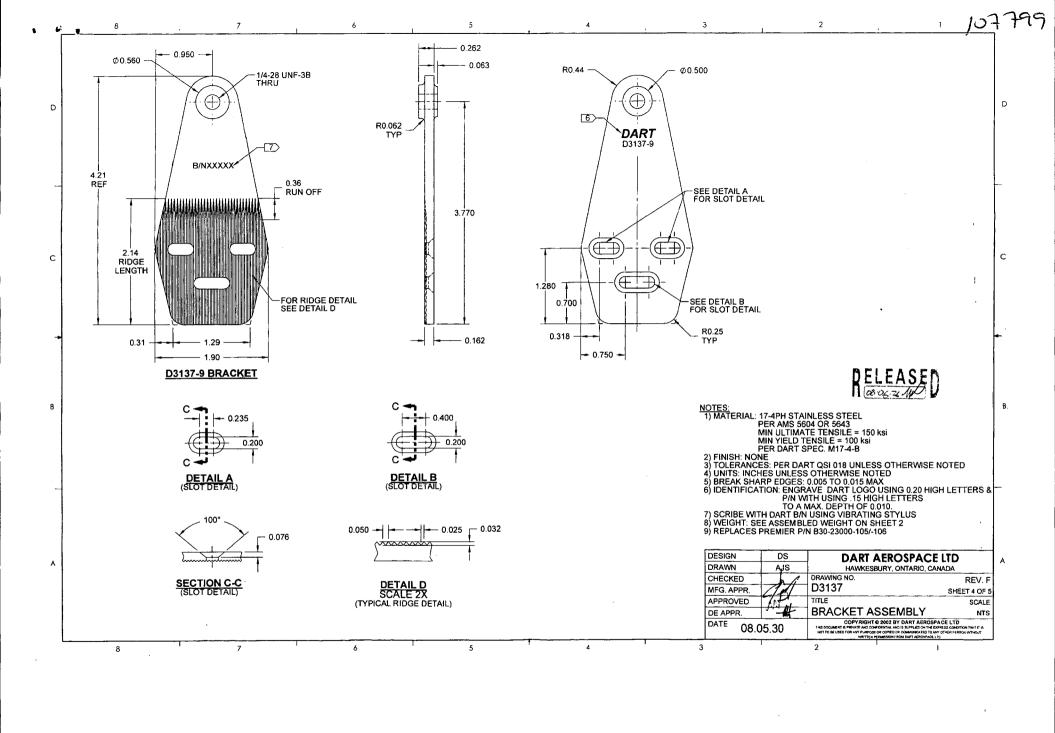
Wave/Twist in Tube

Folio



NCD.	Voc	1	Nia
NCR:	Yes	/	No

Nork Order: Part No.						WORK ORDER NON		NEODA	AANCE / UD	DATE		DQA:	Dat	e:	
Part No. Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Use-as-is	CR: Yes	/ No		·		WORK ORDER NON	I-COI	NFORI	VIANCE / UP	DATE	(QA Closed:	Dat	e:	
Rework Scrap Machining Small Fab Prod. Eng. Coor. Contention Composite Prod. Eng. Coor. Contention Content	rk Order					DISPOSITION			***	AGAINST	DEP	ARTMENT	PROCESS		
Cause Date Step Qty Or Non-conformance Chief Eng Description Date Verification QC or/Data pulp/Tooling perator Ataerial Lettup Chief Concess Lettup Chief Ch	NCR No.					Scrap Use-as-is	t Therm	Machining Small Fab Thermoforming Finishing			Prod. Eng. Coor. Rec/Store/Packaging			ngineering Quality Other	
aulp/Tooling perator Aaterial Perator Aaterial Perator P	1	Date	Step	Qtv		•						_			QC Inspector
FAULT CATEGORY Landing Gear Bending Centre Not Concentric to O/S Broken/Damaged Crushed/Crimped Cuffs Contamination Heat Treat Inspection Strip in Tube Ripples in Bend Grain Grain Grain Hardware Hardwa	o/Tooling rator rator rerial per ress olier raing											,	,		,
Bending							FAUL	T CATE	GORY						
Turning Sequence Finish Out of Sequence Out of Sequence		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Hardwa Inspecti Instruct Mainte Mislabe Misread Offset Out of (ion Incomplete cions Incomplete/ enance eled d Calibration	Unclear		Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W	ssing Vrong	Ten We Wro	ong Stock Pulled



NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:													
····						<u></u>				<u> </u>	QA Closed:	Date	:	
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VOIK OIU	ei.					Rework	7		Skid-tube	Crosstube]	Water Jet	Engineering	
Part I	No.					Scrap	1		Machining	Small Fab	Proc	d. Eng. Coor.	Quality	
	-					Use-as-is	1 ∙		noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR I	No.					Work Order Update]		Large Fab	Composite		Supplier		
Root					Descr	iption of work order update	lni	itial	Actio	n	Sign &			
Cause		Date	Step	Qty	_	or Non-conformance	Chie	ef Eng	Descrip	tion	Date	Verification	QC Inspector	
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		Centre No	ot Concer	ntric to (^{D/S} -	BOM/Route	⊢	iardwa 		 	Over/Under	 	Temperature/Cure	
		Cracks			-	Broken/Damaged		•	on Incomplete	<u></u>	Part Incorrec	<u> </u>	Weld	
•	Crushed/Crimped Burrs						—		ions Incomplete/Un	clear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	-	Cuffs			<u> </u>	Contamination	\vdash		nance	<u> </u> -	Part Moved	1		
		Heat Trea	-	.	-	Countersink	$\boldsymbol{\vdash}$	∕lislabe		<u> </u>	Positioned W Power Loss/		Other	
	-	Inspection		rube	<u> </u>	Cut Too Short	1	Misreac	1	L.	Jeower Loss/:	ourge	Other	
	\vdash	Ripples in		.	_	Drill Holes	_	Offset	Calibration					
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Outside Dimensions

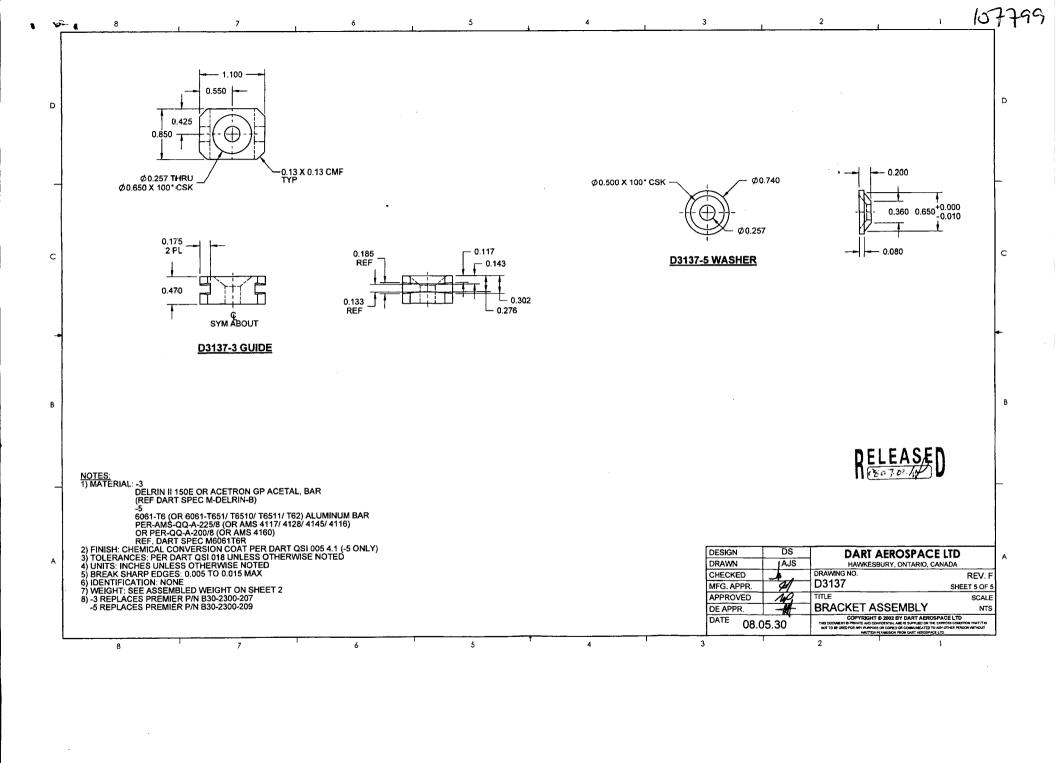
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Wave/Twist in Tube

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		DQA:	Date:	
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Work Orde	ri:				DISPOSITION				AGAINST.	DEPAR	TMENT,	/PROCESS		
Part N	lo				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Coor. C			Engineering Quality Other	
Root				Descri	ption of work order update	In	itial	Ac	tion	S	ign &		T	
Cause	Date	Step	Qty		or Non-conformance	Chie	hief Eng Description				Date	Verification	۱	QC Inspector
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	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence			Ove Part Part Part Pos	lized or/Under t Incorrect t Lost/Mi t Moved itioned W	ssing	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Pressure/Forced Femperature/Cure Weld Wrong Stock Pulled Other
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